



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4682-044
Job Sheet 202083



Part No: D4682-044

Job Qty: 8 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/19

Job Tracking No:

Due Date: 11/25/19

Created By: Marie Lajeunesse

Type: Stock *cap*

Description:

Note: D4682 REV.F/ DSK179 REV.A IPP REV.A 19.09.23 AS PER DWG REV.E DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	8 pcs		11/25/19	0.17	2.00	Waterjet - Flow		<i>02/19/10/30</i>
120	QC 2	8 pcs		11/25/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>02/19/10/30</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S228559



Part: D4682-044

Job No: 202083

Serial No/Batch: S228559

Revision: F/A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/28/19

Plex 10/18/19 10:32 AM Dart.lajeunesse.marie

130 QC 8	8 pcs	11/25/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - Brake NC - B4B	8 pcs	11/25/19	0.25 1.33	Small Fab - Brake - 1 - B4B	DAS 30 NOV 27 2019 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	8 pcs	11/25/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
155 Automated Welding - B4B	8 pcs	11/25/19	0.25 1.33	Automated Welding - 1 - B4B	
				Large Fab - 1 - B4B	
160 Large Fab - Welded Assy-2-	8	11/25/19	0.00 4.00		

B4B	pcs				Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	AL
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
					QC 9 - 10	
					QC 9 - 18	
170 QC 9	8 pcs	11/25/19	0.00	0.00	QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	Q
					QC 9 - 9	
					QC 5 - 10	
					QC 5 - 12	
180 QC 5	8 pcs	11/25/19	0.00	0.00	QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	Q
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Spray Paint - 2 - B4B	8 pcs	11/25/19	0.00	0.67	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19.1.28
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200 QC 5	8 pcs	11/25/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	

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				QC 5 - 81	
210	Packaging 3-1 - Stock - B4B	8 ✓ pcs	11/25/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
220	QC 21 - SA	8 ✓ pcs	11/25/19	0.00 0.00	QC 21 - SA - 21 ✓
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 110 - 1-Cut DSK179-3 as per DWG. DWG. Rev: <u>F</u> PROG. Rev: <u>F</u> 2-Debur if necessary Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - FORM D4682-4 WEARPLATE AS PER DWG 150 - (QC5- Inspect part completeness to step on W/O) 155 - ***USE DT10493*** APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) BATCH: <u>M139025</u> 160 - ***MINIMUM 7 WELDS DISTRIBUTED ACROSS SHIM AND MINIMUM 1 WELD PER INDICATED COLUMN*** 1- WELD SHIMS AS PER DWG A/R Hardcoat S.S. Batch: <u>M136585</u> 2- TRANSFER DRILL 00.188 DRAIN HOLE FROM WEARPLATE THRU SHIM 170 - (QC9- Inspect visual per QSI004- Fusion Welds) 180 - (QC5- Inspect part completeness to step on W/O) 190 - 1- COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9 BATCH: <u>5129587</u> 2- OPEN UP DRAIN HOLE IF NECESSARY TO 0.188 AFTER APPLYING TEXTURED COATING AS PER DWG 3- INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER AFTER FINISH 200 - (QC5- Inspect part completeness to step on W/O) 210 - (Identify as per dwg & Stock Location: _____) 220 - QC21- Final inspection - Work Order Release					

ST 606
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Oscar

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	10.4800 sf (1.31 ea)	110-Waterjet - Flow - 1	S2274012
D4682-13	Saddle Shim	8 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	S227435
D4682-9	Wearplate Shim	8 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	S227435

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S18GA	10	52	0
160-Large Fab - Welded Assy-2- B4B	D4682-13	8	0	0
	D4682-9	8	29	0

Part Specifications

Specifications could not be found.

Plex 10/18/19 10:32 AM Dart.lajeunesse.marie

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		MRB (QS1042)																													
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																													
Description Work Order Deviation				Completed By																															
_____				Lead hand / Supervisor																															
_____				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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